Notebook Series -- Notebooks by Edison and Other Experimenters
Disc Record Book No. 14
Notebook, N-16-05-17

This notebook was used by Edison during May 1916 for notes on experiments to improve the surface quality of Edison disc records. The entries pertain primarily to experiments 1097E through 1137E; there are also lists of other experiments and tasks to be performed. Included are tests involving different presses and varnish compounds, variations in the number of coats and methods of applying the varnish, and differing amounts of pressure and baking schedules. Flaws and successful results are both noted. Also included are notes are on inspections of discards, along with comments on edging experiments. One notation indicates that the results of experiment 1134 were reexamined in November 1916. Some notes are in the form of instructions to Sherwood T. (Sam) Moore or Archie D. Hoffman. Inserted into the book are two loose items, including a note by Edison in regard to Experiment 1134. The front and back covers are labeled "14." The pages are unnumbered. Approximately 140 pages have been used.

12	100
11	91
10	83
9	75
8	66
7	58
6	50
5	41
4	33
3	25
2	16
1	8

67150

Acme Co.,

MFG. STATIONERS,
96 JOHN ST.
AND
19 PLATT ST.
NEW YORK.

Started
5—17—16

Req Dups
Load 2

Press 41

OK OK
OK OK
OK OK
OK OK
OK OK
OK OK

spot	2
specs	3
spec	1
specs	3

OK OK
OK OK

spot	2
specs	3
specs	2
"	2

66%

Req Dup
press 42 - Load 3 -

ok spot on label print bare	3
ok Dull spot next label	3

OK OK

ok specs few	3

OK OK
OK OK
OK OK
OK OK
OK OK
OK OK

ok specs small	3
ok big brown spot	3

58%

5-17-16

Rag Dup 1522 1019 Var
Press 42 Load 3

OK OK
OK OK
OK OK
OK OK
OK OK
Spot — OK 3
OK Specs 3 places 2
OK OK
Bare spot hot op 3
Bare " 3
OK spot — 3
OK spot — 2
OK 2 bare spots 2-3

50%

Rag
Press 41

OK OK
OK OK
OK OK
OK OK
Specs op 2@3
OK specs 3
OK OK
OK OK
OK specs — 3
OK specs — 2
Specs hot op — 2@3
OK specs 3

50%

NOTE

5-17-16 - NOTE

NOTE

Here is a change in position 3 + Pull out question.

Reducing Lamp stock, makes less specs + these are not pulled, but round, yellow in color showing air below, when diamond runs over breaks them — 75% OK - The Varnish runs out over moulds. Miller noticed before when this occurred % was good,

This is the new line to work on - Label blanks + 1 coat 5 cc on machine, and manipulation of Var + baking

SEE 1080-C Var Book 13 -

1097 E

Luhr has made Two Moulds for Hoffman having brass discs representing Label, 002 thick soldered on with Bismuth solder Hoffman to use them all the time and send to me

These tend to come off

5-17-16 not necessary now —

Opened Moulds so as not to pull off direct but little → twist given before removing

The twist dont seem to answer

New Lot Moulds. Hula, + Rosary

Specs " Large area	3 3
OK OK	
Small firm OK	2
OK OK	
Small specs OK	1
Terra specs op	2
Specs Specs	3 3
Bare spot " Bare op	3 3
Specs Specs op	2 2
OK OK	
Specs Specs Specs op big	2 3
Spec small OK	2

25%

Hula

Spec – OK	2
OK OK	
Specs Specs op	3 3
Specs OK	3
Specs Specs	3 3
OK OK	
OK OK	
Specs Specs op	3 3
Specs small OK	2
Specs OK	2 + 3
Specs "	3
Specs "	2

Rosary

1098 - 1st Round

Press 41 load 9

Com OK - Veneer 1/16

OK OK

OK OK

OK OK - 3/4 fill.

Specs (one - Very Specs / short-small) OK OK 3

OK OK

OK OK out at Edge label

OK OK

OK OK fine specs are on bridge wall 3

OK OK " " 3

OK OK

OK OK

100%

2nd Round Press 42 Load 10

Com OK Edge V 1/16

OK OK

OK OK 2 low spots in label

OK OK fine bridge wall specs 3

OK OK fine " " 3

OK OK

OK OK

OK OK

OK OK

OK OK

DISCARD Edge

OK OK

100% print

1098 E

24 1522 blank

Only 1 Coat of Varnish - 5cc

Use the 1 min Viscosity Var 1019

put on Coat - immediately another Coat. Then bake 2 hours at 130°

1099.E

Press 42 Received 10

OK ok

OK ok

OK ok

OK ok Very fine Spec. 3

OK ok

OK ok

OK ok

OK ok

Com OK veneer 1/16

OK ok

Com OK Edge V 1/8

OK ok veneer broken at edge & swamp

100%

2nd Round

Press 42

OK ok

OK ok

OK ok 1½ × 1½ Bridge wall no sound

OK ok

OK ok

OK ok

OK ok Bridge wall low

OK ok Bridge wall area no sound
" "

OK ok

OK ok Bridge wall + Vanish break – don't sound

OK ok looks bad #2 its OK

OK ok

100%

1099.E

24 1522 Blanks One coat only – Bake 2 hours, 1019 var
Bott Van Moochen 5.cc –

Print Regular –

1100 E

NG -

All puffed up, stuck to moulds - took 2 out but put others back in press to run Req to get them off

Shows there is lot of air under pressure under Records

After reprinting they came off moulds freely

1100 E

2 Rounds req 1522 blanks

After 850 lbs have been on for 12 minutes reduce pressure to contact needle just off the pin - hold it there

Cool Cold -

1101 — Round 1
Press 41 Load 9

OK OK
OK OK
OK OK poor print next to labels but OK
specs 3
specs 3
specc — 1
OK
specs — 3
OK
OK OK
OK specs — 3
OK OK
OK OK
Comm. Edge ½ OK
OK specs 1@2

58%

2nd Round
Press 41

specs next label OK 3
OK
OK Big spot — 2
Big spot 3
specs 3
specs 3
" 3
OK OK
specs 2
" 2
" 2
" 2
OK OK
OK specs — 3
OK specs 2
OK spec first time 1
OK OK

25%

1101

2 Rounds

Change schedule
to 1000 lbs instead
of 850 in Reg schedule

1000 No improvement
worse apparently —
too much varnish
makes gas —

1102

OK OK Bridge wall corners

OK OK

OK OK

OK OK Bridge wall corners

OK OK

Spaces of veneer pulled out 1 OK

Considerable space OK OK OK

Bridge wall [illegible] Crushed Edge Discard

OK OK

Com OK veneer + Edge VV

OK OK

OK OK Bridge wall corner spaces

89%

1102E

One round label blanks
Varnished 1 Coat
in the Machine 5cc
bake 2 hours

Ream holes

Print Reg Schedule

Do not need the sunken
Label - Dont do any
good — 5-18-16 -

Printed two of them =

The first one Cracked the blank found pin was too Tight. forcing down by men probably cracks blank
Made another one this was reamed .008 larger (18) the hole,
This printed fully.
Surface very good considering that there is no Var = better than our regulars when we started -
No Run outs, could make a Cornel record of 1000 lbs pressure used -

This experiment shows we only need one coat of Varnish baked 3 or 4 hours to make it a Success -

Surface is nearly as good as Varnish Except Low Center - where Var helps.

1103 E

In one of the Reg rounds use a discard mould put in a 1522 blank no Varnish on -
See hole is reamed -
Print the round regular + note on slip if its in the round

1104

Press 41 load 9

Com OK Veneer 1/8

Com OK Veneer 1/8

OK OK -Spot on Label

Com OK Veneer 1/8

OK OK

OK OK

Veneer discard print OK OK

OK OK

Discard. Edge print ok

OK OK

OK OK

Edge discard ok print
Spaces creamy

91½% print

75% to Stk

1104 2nd Round load 10

Press 42

OK OK

Discard Edge ok print

Discard Veneer OK Print

OK OK

Discard Veneer OK Print

OK OK

OK OK spaces dont sound 3

OK OK spaces dont sound 3

OK OK Edge V 1/16

OK OK veneer V 1/16

OK OK fine spaces bridge walk dont sound

Bridge walk + quick 3 - OK OK
OK

100% pass

1104 E

Make 2 Rounds Duplicating C Varnish of 1080 E

but put on only one coat in machine 5 cc -
Bake 2 hours - 130°

Print Rag

1080

Duplicate 2 Round with this Varnish on Label blanks -

Note that 100g 1 min Vis is better than this showing thinner Var goes into blank deeper + anchors veneer better

1105

Hoffman Cancelled

Make some Varnish use no Lampblack, 1½ Viscosity 8% 6/4 Reg Sandrac But leave out Para altogether,

1106E

Use the Varnish of 1105

One Coat 5cc done on

machine, Bake 3 hours

at 140° fahr

Print Req Schedule

Req.
Press 41 Load 9

OK
OK

OK
OK

Spec op 3
"

OK
OK

OK
OK

Specs from oil 3
" 3

OK
OK

Specs op 3
" 3

OK
OK

OK
Specs 3

OK
OK

OK
OK

66%

Req
Press 41 Load 9

OK
Specs 3

Bare spot 5/8 2
OK

bare spot 2
specs

OK
OK

OK
specs 2

Specs
Specs op 3

Bare spot
spec op 2

OK
Specs near latch 3

big spec pull out 3
Specs 3

Specs 3
" 3

OK
Spec 2 @1

OK
OK

16%

* means no record of position etc

Reg
Press 42

*
*
OK
OK
*
*
*
OK
OK
*
*
*
*
*

16%

Too much Var or not thorough baking makes gas — No pull outs —

3 Coats is a mistake,

Single Coat long baked is what's wanted

3.5 or 5. cc 2 @ 3% Lampblack

or none,

1107 This is D Var of 1080 Book 13

2nd Round 41 press

no record of bad pos

Press 41 – Load 9

OK Yellow spots not pull out, 2	OK OK
Diagonal 1/2 x 2 1/2 red spots both sides — no pull out	OK OK
OK OK	OK OK
	Com OK Edge
Air	OK OK
Air	
Air bubs	
OK	X
OK air bubs	X
Awful bubbles not open no PO	X
few bubs	X
Fern big not pulled out	X
OK few bubbles	X
OK bubbles swelled out	X
bubs bubs small. 1/2	

8%

41%

1108 — 1st

Press 41 — Load 9

OK OK

OK OK

specs veneer — OK OK

Discard — Veneer specs — OK

OK OK

specs too much OK

OK OK

specs specs big area

specs specs OK OK 3

Com OK — veneer 1/8

OK OK

specs fine OK

50%

58 —

2nd Load 9

Press 41

Discard Veneer

OK OK

specs specs probably ink on Machine

specs OK "

specs OK "

Com OK — Veneer 1/16

Bad specs OK

Discard Veneer OK

Com OK — Veneer

OK OK

OK OK

print OK Discard, V Edge to mach. OK

1108E

2 Rounds 1522 - reamed hole slightly larger after baking

Use Varnish "D" one coat

355° bake 4 hours

Print Req

1108 } are Duplicates by
1109 } Mistake —

No Lamp block in D

1109 - 11

Press 41 Load 9

OK NOK Specs " Edge Discard

Com OK Veneer

Discard - Veneer

Discard - Veneer

OK OK Specs OK

OK OK Print Edge Discard

Com OK - Veneer

Specs Specs OK OK

Com OK - Veneer

OK OK

OK OK

11

63% 73

Edges clean

2nd Round Load 10

Press 42

Print OK Discard Veneer

Print OK " Edge + Veneer

Com OK - Veneer

OK OK

Specs big crack OK OK OK

OK OK

Specs - bridgewell OK OK OK

Print Specs OK Discard - Veneer + Edge

Print OK " Veneer

Specs + Veneer OK OK OK

Discard Blank Broken 1/2 of Edge cuts inside

" " "

25% 50%

1109 E

2 Rounds 1522 bush reamed + hole enlarged after Varnishing

Use Varnish "D" of 1080 E

Use 3.5 cc One coat

Bake 4 hours

Print Reg 4 hours Bake

Bad - Edges bad Crack -

NOTE

This Varnish together with long bake does not weld the Varnish like Lampblack — + there also seems too much broken Edges, 1108 is Duplicate

D Var 1½ Vis no good Cant say about 4 hours bake

1110-

41 Load 9	42 Load 10	42 Load 10	41- Load 9
Stick to Mould 4	Stick Mould 4	Stick 4	Cut Margin 1
OK OK	Com OK Veneer 1/16	OK OK Spot Low pt	OK OK
OK OK	Com OK Edge	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK Low spot 3
OK OK	OK OK	Com OK Edge	OK OK
OK OK	OK OK	OK OK Low spot 3	OK OK
OK OK	OK OK low spot 3	OK OK low spot 3	Discard - Edge bad ok
Discard - Edge ok	OK OK	OK OK	OK OK
Discard Edge	OK OK	OK OK	OK OK Low spot
OK OK low spot 3	OK OK	Com OK Edge ✓	OK OK Low spot
OK OK	Edge - Dised ok	OK OK	OK OK
Com OK Veneer	OK OK	Com OK Edge 1/16	OK OK
DISCARD Edge ok	OK OK	OK OK	OK OK
OK OK	OK OK Low spot 2	OK OK	
75%	91%	100%	91% 100% Print

1110E

1522 B - Means no hammer used -

48- 1522 No hammer blanks 1522B

1 Coat 5cc 1 min Viscosity

Bake 2 hours - 200°C

Print Reg

1522 B

5-18-1916-

Technique now-

Blanks 1522B. no hammers

Varnished one coat 5 cc

of 1 min Viscosity 1019 Var

Baked 2 hours

Reamed at hole for bushing below,

Printed regular schedule

Contact needle off pin when 200° reached put on 850 lbs 12 mins Cool cold.

~~Holes reamed .008 larger to stop cracking of blanks~~

~~1~~ 1111 E

Press 42 Load 10

OK
OK
OK
OK
OK
Discard Veneer
OK
Com OK veneer 1/8
OK
OK
OK
OK
Com OK Edge V 1/16
OK
OK
OK
OK
Com OK veneer 1/16
OK
OK

91% 100% points.

No Van record is pretty Rough

1111 E

Hoffman Make 4 Rounds 1522 in moulds that have the rough faced plastics used with old transfer Blank-

Varnish 1 coat 5cc on Machine with 1 minute Viscosity Varnish Bake 2 hours

Print ~~with the~~ Req be sure one round has the Discard mould ~~to~~ use blank not varnished

Notes -

Notice Scraping off Wheel all chewed up on Edges + rounded - This should be inspected + trued up often

Fixing bushing in mould well
Cut the rise in center flues perhaps new bush necessary =

Moore oil may come from bearing of scraping off wheel creeping -

1112
Press 41 Load 9 –

OK OK — see opposite side for lack of fill.
OK OK
OK OK
OK OK
Discard Edge OK
OK OK
OK OK
Discard-Edge OK
Com OK — veneer
OK OK
OK OK
OK OK — can hear this ① but OK

83% 100% proof

1112 E

Hoffman

Find 12 blanks with most spaces of metal & largest pick them out, send over to Wallace Varnish & Run them Req

It is all right to pick out of face the steel chips if not scraped too deep – Careful work will save them all –
The only effect is that at spot it not a full print

5-18-16

1522 B 1 Coat 2 hour bake
1 min Viscosity - 1019
Var up slaw

This shows No hammer blanks, 1522 B are ok

also 1 min 1019 Var ok.

The bridge wall areas are due to the 6" Center diameter of all blanks is lower than The Edge Circle as shown by the Printing of the Non varnished blank
+ that bridge wall areas are Really only a 3/4 fill.

We should bring Center of Blanks up a little more

Bridge wall only makes surface a little rougher as it not consolidated like a full Print -

5-18-16 1522 B
New Series -
Reg # 1 Round

OK OK
OK OK #3 Bridge W large Contamination only roughens surf
OK OK
OK OK Bridge wall area 3
OK OK Bridge wall area 3
OK OK
OK OK Bridge wall area 3
OK OK
OK OK Bridge wall area 3
OK OK Bridge wall area 3
OK OK

11

100%
1st Record of 5-18-16 Technique -

Press 41 1522 B
2nd Round

OK OK
OK OK Low print spot 3
OK OK
OK OK
OK OK faint low print spot 3
OK OK Low print spot + Kolt stain on label. 3
OK OK
OK OK Low print sounds but looks OK Decard 3
OK OK
OK OK
OK OK
OK OK Low print all around at # 3

91%

Reg's. give clean edges -

Moulds are also clean -

3rd Reg 1527 B -	4th Load 10	5th Load 10	6th Round Load 9
42 Press	42	42	41
OK	OK	Discard, Edge	OK
OK	OK	OK	OK 2 low spots 3
OK Low Pnt spot 2	OK	OK	OK
OK	OK	OK	OK
OK	OK	OK	OK
OK	Com OK Veneer 1/16	OK	OK
OK low pt spot 3	Com OK Edge ✓	OK 2 low spots 3 big	OK big low 3
OK	OK low spot 3	OK	OK
OK low pt spot 3	OK low spot small 1	OK	OK low spot 3
OK	OK	OK	OK low spot 3
Com OK Edge ✓	OK	Com OK Veneer 1/8	OK
OK low spot 3	OK	OK	OK 2 big low 3
OK low spot 3	OK	OK	OK
OK			
100%	100%	91%	100%
Edge 1	Edge 1	Edge 1	Edge none

7th Load 9	8th – Load 10	Reg factory hand 9th	Reg factory 10th
41	42	41 Load 9	41 Load 9
OK OK	Veneer pulled out OK Edge Music	OK OK	OK OK
OK OK low spot 3	OK OK Low spot 3	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK low spot 3	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK low spot 1	Com OK Edges
OK OK	OK OK	OK OK	Venecci OK DISCARD
OK OK	OK OK lowspot 3	OK OK	OK OK
OK OK low spot 3	OK OK low spot 3	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK lowspot 3	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK lowspot 2	Edge OK DISCARD
OK OK	OK OK	OK OK	OK OK
100%	91%	100%	83% 100% prime
Edge none	Edge none	Edge none	Edges 3

11th	12th factory	13th factory	14th
42 Load 10	41 – Load 9	42 – 10 Load	
Mould Pullouts 2	No Pout. Mould	4 Pullouts – 1 Load Edge	
OK OK	OK OK	Veneer DISCARD OK	
OK OK	OK OK Low allowance 3	Edge DISCARD OK	
OK OK	OK OK	OK OK	
OK OK	OK OK	Com OK Veneer 1/16	
OK OK	OK OK	OK OK Low spot 2	
OK OK	OK OK	OK OK Low Spt 3	
OK OK Low spot 3	OK OK	OK OK	
OK OK	OK OK	OK OK Spot low 3	
OK OK	OK OK	OK OK Low Spt 3	
OK OK	Com OK Edge	OK OK	
Com OK Veneer	OK OK	OK OK	
OK OK	OK OK	OK OK	
OK OK	OK OK Low Spots 3 of Com		
100%	100%	83% 100% Pt	
No Edges	1 Edge		

5-19-16

Inspection of 1522/B blanks

Blanks within 012 Calliper OK

" " 020 " Seconds

Blanks beyond 020 to be held for further orders

Special defects causing discard to be held for further notice

Steel in face of blanks if small is to be passed if large held for special operation —

Give me a dozen with many specs & I will mark those which may pass.

250/1000 Maxim for thickness

Crush Edge Exp'mt Moore Expt.

Printed without pins —
Inspected for Crushed Edges only

OK OK out of line from discards

OK OK "

OK OK " Bad

— 1/32 Edge not pulled out — Veneer drawn a little showing slight Crush

OK OK out of line Bad

OK OK slight almost in line

OK OK out line Bad.

Nothing in this Theory

Theory was pins at angle of faces of faces shifted

Demonstrates Theory

1113 E

12 blanks 1522 B with rubber 6" dia. $\frac{1}{32}$ thick added to Reg Pressure Rubber to make middle of blank thicker, it need being low —

Print 1 on each Round - 6 Rounds load 9 + 10, No Varnish on blank —

This was done + They were very much more even, it also appeared to stop crushed edges

14th Factory	15th Factory	16th Factory	17th Factory
1522 B	—	—	—
42 – 10 Load	42 – 10 Load	42 Load 10	41 – Load 2
Mould no PO	Mould no PO	no puff outs (mould)	no mould PO
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK L Spots 3	OK OK	OK OK
OK OK	OK OK L spots 3	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK
	OK OK	OK OK	OK OK
OK OK	OK OK L Spot 3	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK L Spot 3	OK OK L Spot 3	OK OK
OK OK low spt 2	OK OK	OK OK L Spot 3	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK L Spot 3
OK OK low spt 3		OK OK	
OK OK			
100%	100%	100%	100%
no Edge	no Good Edges	no Good Edges	no Good Edges

Average to clock 88.6 to this point.

18	19	20	21
factory production.			
42 - load 10	41 - load 9	42 load 10 -	42 - 10 load
1 label PO	None attack	none attack.	none attack
OK OK	OK OK L Spot 3	OK OK	OK OK L Spot 3
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK L Spot 3	OK OK L Spot 3	OK OK	OK OK
OK OK L Spot 3	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK L Spot 2	OK OK	OK OK	OK OK L Spot 3
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK L Spot 2	OK OK	OK OK L Spot 3	OK OK
OK OK	OK OK	Com Veneer ½ OK	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK		
100%	100%	100%	100%

All reg have clean Edges
Varnish dont come over
also Moulded Edges
clean —

No Var blank in 24th Round — 1113E Lot
Evenly printed, even shine all
over — one face shows spot,
some much came out of blank
+ made 15 knocks —

25th Round Non Var blank
Even shine —

22 factory	23	24	25
42 load 10	41 — load 9	42 — 10 load	41 — 9
No PO	No Pull outs	5 pull outs Marred Scratch	1 pull out (marred)
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK L Spot	OK OK	OK OK L Spot 3
OK OK	OK OK	OK OK	OK OK
OK OK L Spot 3	OK OK	Com OK Edge $\frac{1}{16}$	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK L Spot 3	OK OK	OK OK L Spot 3	Com OK Veneer $\frac{1}{16}$
OK OK	OK OK	OK OK L Spot	Com OK Veneer $\frac{1}{16}$
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK L Spot 3	OK OK L Spot 3	Com OK Veneer Edge V	OK OK
OK OK	OK OK	Com OK Edge V	OK OK
OK OK	OK OK	No V Blank	Non V blank
OK OK	OK OK		
100%	100%	100%	100%

Many feathers hole too small
have them thrown out +
fixed

26	27	28	29
Factory Production 41 — 9 hour	41 — 9 hour	41 — 9 hour	42 — 10 hour *
None struck	None struck	4 Points -	2 pull outs
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK
Com OK Edge 1/16	OK OK	OK OK	OK OK big low position 1
OK OK	OK OK	OK OK	OK OK big low 2nd
OK OK	OK OK	OK OK	OK OK big low 2nd
OK OK	OK OK	Com OK Edge 1/32	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK L spot 3	OK OK	Veneer OK DISCARD
OK OK	OK OK	Com OK veneer 1/16	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK big low position 1	OK OK L spot 3
100%	100%	100%	91%

Moores Expts to find out cause of raised spots + rising Edges on blanks when heated 200° Fahr in press

1 = Finger marks dont produce them
2 = Salt (dry) dont produce
3 Machine Oil "
4 Sesame oil - "
5 Alcohol "
6 Water this produces them
7 Spittle marks - This produces it
8 Solid Crys 6/4 This produces them good
9 Para (solid) this produces them -
10 KOH (solid) Dont produce
11 KCy " "
12 phenol " "

Water + 6/4

33 Rounds 93.55 OK

30	31	32	33
1523-Lot 4	Lot 2 15223	Lot 6	Lot 7
41-Load 9 no pull outs	42-Load 10 Nameplate	41-9 load No Sticks Moved	42-10 load 2 pull outs -
OK OK	OK OK bad low 3	Com OK veneer 1/16	OK OK
OK OK L Spot 3	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK spot 3
OK OK	OK OK low spot 3	OK OK	OK OK
OK OK low spot 3	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK Focus 3
OK OK	OK OK	OK OK	OK OK low spot 3
OK OK	OK OK	OK OK	Com OK Edge V
OK OK	OK OK	OK OK	Com OK veneer 1/8
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK Spot 3	OK OK focus spot 3	Com OK veneer Com OK Edge V	OK OK
OK OK Spot 3			
100%	100%	100%	100%

34	35	36	37
1522B Lot 8	Lot 8	Lot 8	Lot 8
41-load 9	42-10 load	41-9 load	42-load 10
none shock	1 Puff out	1 in Lates	none
No Var OK even	no Var Even	no Var Even	no Var Even
OK OK	OK OK	Veneer OK DISCARD	Edge OK DISCARD
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK Spot 2	OK OK —spot— 3	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK	Corn OK Veneer	OK OK	Edge OK DISCARD
OK OK spot - 3	OK OK Spot 3	Corn OK Edge ✓	OK OK
OK OK spot 3	OK OK	OK OK	OK OK
Veneer DISCARD OK	OK OK	OK OK spot 3	OK OK cellaround 3
OK OK	OK OK Spot 2	OK OK spot 3	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK
		OK OK	
91%	100%	91%	83%
1 Edge			

1114 Press 42 - Load 10

OK OK

OK OK

OK OK all around faint low due probably to label or Van low

OK OK

OK OK } low long spot opp - No 2 position

OK OK

OK OK

OK OK low all around probably due to label or varnish low -

OK OK

OK OK

OK OK Think bad Moulds may have something to do with last 3 Rounds

100% No Veneer or Bad Edges

for other 3 Rounds see 3 sheets Ahead

1114 E

Hoffman - Make 48 blanks like 1113, with the Extra 6" X $\frac{1}{32}$ Rubber on bag Rubber

~~Print~~ 4 Rounds 1 coat
1 min Viscosity
2 hour bake

Print Req 1522 B schedule

This dont stop low spots at 3rd position
other 3 Rounds 3 sheets ahead shows bad Veneer + Edge Discards + Low spots

Pressing blanks 15228 between record
Mouldes 850 lbs NO Heat.
only makes Tit impression circle on
Label faint + only traces of
record vibrations —

It does no Harm —

No1 -

38	39	40	41
Lot 5		Lot 8	Lot 8
41-9 load	41-9	41-9 load	42-load 10
2 on Margin PO	1 1 PO on Margin	no PO	2 on label 2 on Margin
No Var Even	No Var Even	No Var Even	No Var a little uneven
Com Edge ok	OK OK	OK OK	OK OK
Com Edge ✓ ok	Com Venn + Edge OK	OK OK	OK OK Spot 3
OK OK	OK OK	OK OK	OK OK all around 3
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK one pull out Spot 010 but OK
Veneer OK DISCARD	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	Edge OK DISCARD
Com ok veneer ✓	OK OK	OK OK	OK OK
Veneer OK DISCARD	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	Com ok veneer
OK OK			
83%	100%	Perfect Record 100%	91%

Nothing Comes out on Edge — Clean

43 Rounds

42	43	44	45
Lot 8	Lot 8	Lot 5	6 Lot
42-loaded 10	42 - 10 loaded	42 - 10 loaded	41 - 9 loaded
2 PO on Label	none 1 bad Edge	none	2 pull out 5 when
No Var fairly Even	No Var Shade Uneven	OK OK	OK OK
OK OK Spot 3	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK Spot 2	Com OK Edge V
OK OK	OK OK	OK OK	Com OK Uneven
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK Spot 1	OK OK Spot 3	OK OK
OK OK	OK OK	OK OK	Com OK Edge V
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK
Uneven OK DISCARD			Com OK Bad Edge
OK OK			
91%	100%	100%	100%

47 Rounds

Discard for Edges 10
" for Veneers 8
18

Edges that can be edged OK 18
Veneers " " 15

Veneer Discards can probably be used for dispensers

RESUME

Total discards for Veneers + Edges 1/3rd of 1%

~~Average to here~~
96.3% OK

46 Lot 7 42-10 L	47 Lots 41-Load 9	48	49
4 Bad Edge 1 Pull out	3 Pullouts		
OK OK	Edge OK DISCARD		
OK OK	OK OK		
OK OK	OK OK		
OK OK Spot 3	OK OK		
OK OK	OK OK		
OK OK	OK OK		
OK OK	OK OK		
Com OK Veneer 16	OK OK		
Com OK Veneer	Com OK Edges		
Edge OK DISCARD	OK OK		
Edge OK DISCARD	OK OK		
Edge OK DISCARD	OK OK		
75%	91%		

1114 E

2nd Round 41 – Load 15	3rd Round 42 – 8 Load	4th Round 41 – 12 load
Edge + Veneer OK DIS	OK OK	OK OK Low 3
Com OK Veneer	OK OK	Com OK Veneer + Edge
OK OK	Com OK Edge ✓	Com OK Veneer + Edge Low 3
OK OK	Com OK Veneer -	OK OK
OK OK	Com OK Veneer Low spot	Com OK Veneer
OK OK	OK OK	Com OK Veneer
OK OK Low, due to Stretch 3	OK OK	OK OK
Veneer OK DISCARD	OK OK	Veneer OK Discard
Com OK Veneer	Com OK Veneer Spot 3	OK OK Low all around 3
OK OK	Veneer OK DISCARD	OK Com Low all round 3 Veneer
OK OK Low spot 3	OK OK	Veneer OK DISCARD
Edge Edge/Gouch DISCD	OK OK — Low spot 3	OK OK
75%	91%	83%

1115 E

12 1522B printed without Varnishing 1 in each Reg Round – Made with Extra 6" X 1/32 rubber in middle of big Rubber Blanks 10 perfectly Even 2 slightly uneven

42 - Load 9

1 OK Salvin -
2 Jumps over
3 OK Bad Label
4 Bad fill
5 Bad fill
6 Bad fill -
7 "
8 "
9 "
10 "
11 "
12

3 position

By manipulating
Technique on Varnish
getting Middle blanket
higher at 3 position
at 1000 lbs in Print
preserves final
think we can
make Repeats
75% OK

Surface general

1115E

Reprint -
Varnish 1 Coat 1 min
Viscosity 1019 Vari -
1 round of Reg 15223
Records - Dry 2 hours
Print rzg

1116E Edwing

1= 1/4" dont cleanit = 3/16 well
2 This has only 1/8" margin left
3 [illegible] - blank cleaned but Veneer PO
4 Blank cleaned ok but Veneer pulled - 3/16 left
5 OK - 1/4
6 OK 1/4
7 clean up with 5/32 Margin
8 1/16 margin left.
9 3/16 margin left ~~Blank~~
10 OK
11 5/32 margin left
12 OK

1/4 + 1/32 3/16

33% 58%

1116E

12 Prints which were ~~sup~~ supposed to be discards for bad Edge but which were not actually chipped out Except a part, but from the appearance of the Veneer might External further than apparent & be a discard
The standard is 1/4" but I find it 1/32 more than this on some of Edged records returned -

Note

Requires 370 lbs Chalk

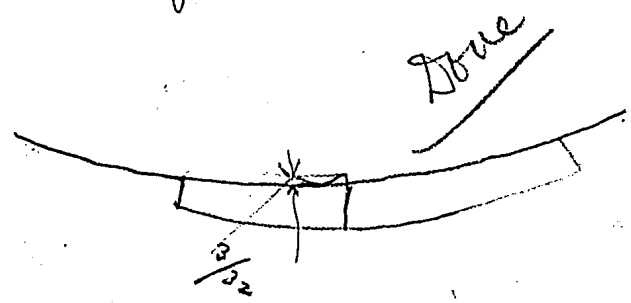
per 1000 1522B Blanks

Inspection for discard blanks
Edges.

1 Nicks within 3/32 of Edge are
2 OK.

More than 3/16 Discard

have gauge made



24 Blanks
13 Discards
11 OK within the 3/16 limit

Calliper of Old Transfer Records from Baldwin
10 of them — 1297 Blank

		Dif-
227	217	10
226	225	1
227	232	5
232	230	2
238	228	10
225	225	0
226	218	8
218	218	0
240	222	18
230	233	3
2289	2248	

Highest 240

average 226

Calliper of 12 New 1522B Records

216	213	3
211	205	6
216	216	0
224	216	8
205	211	6
207	217	10
223	223	0
212	212	0
208	213	5
220	217	3
235	222	13
217	213	4
2594	2578	

Original blanks not above 250. were used,

Some days mean days gets lot over 250 other days under 250.

average 215 1/2

1522 B
Calliper for Worst.

They use a Micrometer gauge when over 235 — 1522B are nearly all over 235 - hence solid gauge not used —

Man says chipped Edges due to striking Edge of one blank on the other by sliding on the pile —

I think some are chipped by the Snap gauge & I believe by the Micrometer - also rolling on Edge to Calliper

Difference		Thick
15	26	262
13	16	253
16	11 — note	255
18	20	251
20	16	253
17	note	253
20	12	255
25	17	
15	18	
13	25	
17	25	
7	15	
30		

above 250 ballance below 250

note - Useless inspection

New 1522B Blank Inspection

no Calliper for thickness

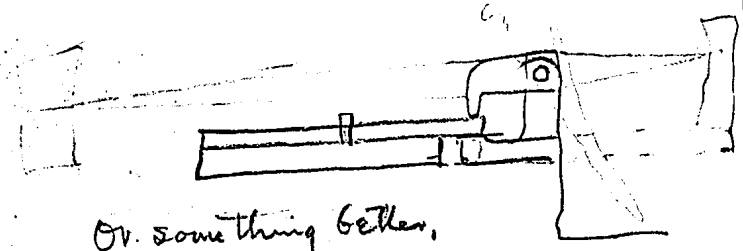
Anything ~~under~~ 260/1000 OK

Chipped Edges Extending in not more than 3/32 OK

Callipering for diference of thickness not necessary Abandon it,

Inspect for steel and holes, dirt, Etc

Get a special gauge for Quick calliper for thickness



Or something Better,

1117E

8 Rounds of discard blanks. discarded for too great diference in Calliper up to 30/1000.

1 Coat 1 min Vis 2 hour bake - 1019 -

Print Req 1522B schedule

See next page for results →

1st Round	2nd	3rd	4th 42 pieces - 12 load
41 - 9 load	42 - load 8		
Probably Down Edge	Veneer Edge OK DISCARD	OK	Com OK veneer
OK	OK	OK	OK
Veneer DISCARD OK	Com OK Edge V V	OK	OK
OK	Veneer " DISCARD	Com OK veneer	Com Com Veneer
OK	Com OK Edge V V	Com OK veneer	OK
OK	OK	Veneer DISCARD OK	OK
Veneer DISCARD OK	OK	OK	Com OK Edges V V Veneer
OK	OK Com OK veneer	Com OK veneer	OK
OK	Com OK veneer	Com OK Edge V Veneer	OK
OK	Com OK Edge V Veneer	OK	OK
OK	OK	Veneer DISCARD OK	OK
OK	Com OK Edge V	Veneer DISCARD OK	Com OK Edge V
OK			OK
75%	88%	75%	100%

5th	6th	7th	8th —
Lot 8 - 42 pieces	41 - load 11	42 - load 6	Pieces 42 load 13
OK	OK	OK	OK
OK	OK	OK	Com OK veneer 1/8
OK	OK	Com OK veneer 1/16	OK
OK loose spot 3	Com OK veneer 1/16	OK	OK
Com OK Edge V	OK	OK	OK
OK loose spot 3	OK	OK	OK
OK	OK	OK loose spot 3	OK
Veneer DISCARD OK	OK loose spot 1	OK	OK
Veneer DISCARD OK	OK	Veneer 1/8 OK	OK
OK	OK	OK	OK
OK	OK	OK	OK
OK loose spot 3	OK	OK	OK
	OK loose spot 3		
83%	100%	100%	100%

Moore says Comm cases 1/2 of
2 = Uteen & Thum make room

4 = Sent for one - 5=22-16 4 OK works

Note

5 = ordered

7 = Notified Hud & Hoffman

Notes

1 = Storage place for Transfer plates & mandrel holders - greased up -

2 = Remove and store tables on which allowed plates are placed, greased up - only small room at first

3 = Rig up to ~~change transfer process~~ into Print ~~process~~ -

4 = Experiment on Edging Mandrif lots ~~without accepting~~ records -

5 = Try 4 Records with Extra Variat ~~of action~~ 3 on 152213
Extra rubber on Rubber plunger

6 Expt Water proofing Edges

7 Stop Chipping out of Blank Edges in Hoffman Dept.
& all along the line -

8 = Dont work good - Dunwiddie Expanding

11 = Is Expanding

14 = Dont stop low spots, Wear or Edges

8 = See how new larger magnet works if it dont do it put another in ~~[illegible]~~ & divide the drop -

9 = Inspector picking steel out & scraping -

10 = Keep Floors on the drapes of liquid that sweeps up

11 = Dunwiddie Expt on roller equalizer pulling on Vacuum.

12 = Emergency Storage sealed Cans mouths & apply grafite - in Vault

13 = Specially sifted Very much finer powder 1522 B for print Kit Marlen & water proof

14 Watch new 6" $\frac{1}{32}$ Extra pad on Rubber plunger to see if it stops low spot print & broken Edges by Evening up pressure

15 See if Can stick paper label on Edge of record & have it water proof Same time

16 Edge & number 4 Rounds new record - I to inspect them - Looked & all

17 Lathes 9 & 10 to be kept running - Hand Inspector to watch & report any taken off & why & I to listen to print off deskards mould

18 - Immediate Experiment of 2 8" hardened disks for grinding Lamp & Lock - Bagaduce type & Closed to prevent Corporation -

19 - New loader for powder on moulds & Saving them

20 = Write Every ~~Wanted~~ 3 Days
Every working Day OK

24 = Hang paper

Note

20 = See Every ~~about~~ ~~Supply of~~
Chalk ~~of~~ ~~Extra~~ Newage Screen

21 - Have we an Aluminia
screener used by Cement Co
for sampling 180 Mesh Size

22 = Do we keep wear & spare
parts for Fuller Mech-
& have Mallory answer
about his giving us 2 Medals

23 Find storage for Hammer
Loaders grained up & use
space for increased Capacity

24 Devices for proper handling
of blanks, so not hurt Edges
or scratch surface

25 = Pulverizer the high Tins
+ bake + Let me have
4 Rounds

26 = Soak 1/2 dog accords
3 hours in water seeing
any holes in Mucic -

27 Make wear tests on bands
till 500 times - Then
1 quid is all we ever need
1/4" sufficient.

28 - Christensen make Cold
tests - Then oven heat
180 then Illness in Burner
use 1/2 dog -

29 Put on roof to Edged +
waterproofed accords
for weather test
also 1/2 dog lots of seals
30. places

31 = ~~Lubr gauge for Chip outs~~
~~in Edges of blanks~~

31 = Fred Ott making Demo OK

32 - ordered & now being done

note

33 OK done, must be not less than 7 - 8" w beat,

34 OK done — note

35 OK Recorded

36 OK works OK

32 = take off inspection limit on variations of Cartridge powder blank or Unwaxed

33 = test 4 Rounds 8 min Cool
4 " 4 "
Ordered

34 Req schedule 850° for 10 min
7 Cool — 4 Rounds
ditto 4 Rounds 850 — 8 min
7 cool
ditto 4 Rounds 850 6 "
7 Cool
ditto 4 " 850 15 "
7 cool

35 = 4 Rounds Rubber pad heavy
6" 1/16 thick

36 get mandrel & assembla
records for Edging
& Inspect for scraping

37 = Molded Ebony - OK —

Mole

40 — 575 000 Records Disc

37 = Also Ebony from Conteydeny for 6/44 formula also also Key & Acetal

38 Make some 1 min Vio Kaw for 4 Rounds No para or Sandma — Make Ear + wear tests

39 - Ditto 4 Rounds. Para but no Sandma

40 - Certain Maximum Storage Tycylcoins Dept

41 for Cylinder records Molded Cylinder 1522 B then Varnish + percent Hot air.

42 = Take up subject sheathing Hoffmans dept steel sides & overhead or members of truss, — Sprinkler system steel columns Skylights other places

43 - Make more dropping tools

44 = ~~new 6" x 1/32 mesh with Extra Vent at 3 positions 4 Rounds~~

44 Abandoned

Note

45 = Wash face second coat Alcohol side of hurt

Note

46 = Add one pair Tracked moulds to Lead 9 + 10

47 Now being made

47 get up complete list of forms & forms (Numbers for daily reports

49 abandoned

53 it was Collyman, has it there now —

48 = Put on the Thermometers

49 — Hoffman 4 rounds with 6" x 1/32 Emmanuelle on rubber disc but with hole in center exact size of Label —

50 = See how many rotating Varnish pots we get in use & how many wanted —

51 = Time the output of the Varnishers —

52 see if Record washed after numbering & Varnishing otherwise might get water in & swell Edge of Record

53 = Find out who need fuller Mill from Cement Co & who sent it back —

1118 E

One round 1522 B.
Reg Schedule Except
Cool Six minutes

Press 42 - Load 12

OK OK Spot looks like Copper dont sound.

OK OK 2 snapped out end - pull outs.

Veneer Discard

Com OK Veneer + Edge

Discard Veneer

Com OK Veneer

Veneer Discard

Discard Veneer

OK OK

Veneer Discard

Edge Discard

Veneer Discard

All discards are on Tape side -

41 %

1119E

One Round 1522B-
Reg schedule Except
Cool 5 minutes

Veneer Discard
Veneer Discard
OK
OK
Edge Discard
OK
OK
Veneer Discard
Com OK Veneer + Edge
Com OK Veneer
Com OK Veneer
Veneer + Edge doubtful
OK
OK
OK
OK

58%

1120 E

One round 1522 B
Req Schedule Except
Catal 4 numbers

Pieces 42 Loaded 7
Veneer Discard-all around
ok
Com ok Veneer 1/16
Com ok -Veneer 1/8 clean Label
Discard Veneer
"
"
"
"
"
"
ok
Veneer Discard
Veneer Discard
Pull outs (2) in music
Veneer discard
ok
ok
ok
Com ok Veneer 1/8
Veneer Discard
Veneer "

33%

2nd Round 1121 E

42 pieces
Load 6

OK OK low at Position 1 ok

Com OK Edge V

OK OK

Veneer DISCARD OK

Com OK Veneer 5

OK OK

Com OK Veneer 5

OK OK

alcohol out of mouth - Carelessness — negative

ok Discard

chip out of Edge blank in handling show Kinder DISCARD

ok Discard

Veneer OK silver spot ok

Com OK Edge

75%

1121 E NOTE

Low spots due to varnishing —

No low spots at 3

also note 1128 - low spot at 1 —

2 Rounds 1522 B.

1 mm Vis 1019

1 Coat all over after it's air dried put Extra Coat at Position # 3. — Ilen Baker 7 hours

Print Reg

Press 4 - Load 3

Veneer Discard OK

OK OK

Veneer DISCARD One

Com OK Edge V

OK OK

Veneer DISCARD OK

OK OK

OK OK

OK OK

Com OK veneer

OK OK

Com OK veneer

No low spots.

75%

June 5=22—16—

Start

Bring Mould from Assembly R	1.44
Press Loaded	1.45
Bring in Contact	1.46
Bring to 200° Fah	1.48
On Heat 12 min	2.00
Start to Cool	2.00
Cold-	2.07
Drop press Eject on truck	2.08
Returns Mould to Assembly Room	2.09

Total time one cycle 25 minutes

from press to Assembly Room
back to Press averages
11 Minutes —

2nd Lot Discards

1 — Scratched record
2 Dust on Varnished blank —
3 white dust 1 side — fibre on Var other side
4 — Scratched Varnish
5 Pull out,

only 5 of 1 Coat,

Inspection of Discards
1522 B 1 Coat,

1 = Inspector Carelessly let down
Replace point & diamond & spoil record

2 = pull out at feed line
3 " " "
4 " " "
5 = Piece wood. Either blanks or mould —
think was on mould =

6 pull out.
7 Dust —
8 Pull out.
9 one snap, shaved press } its in mould
10 " " } both same spot
11 long piece wood fibre Knocked out —
probably on. The ~~[illegible]~~ Var after or just
before baking
12 ok too many snaps —
13 = This is a 1522 But 3 Coat
Varnish — got mixed

Inspection of Discarded Called
1522B — SCRAP

3rd Lot of 12

1 — Crushed Edge NG
2 " NG
3 " NG
4 Veneer NG
5 Crushed Edge NG
6 Veneer NG
7 " NG
8 " NG
9 Edges Crushed NG
10 Veneer + Edges NG
11 Veneer — NG
12 " NG

All Properly segregated for Regrinding - Except Veneers which may in time be used for revarnish & Repaint.

1122 E

One round 1522 B.
Reg Schedule Except
Cool 8 minutes.

42 pieces - 9 Random

OK		6 min	41%
OK		5 "	58
OK		4 "	33
OK		8 "	100%
Com OK	veneer 1/8	% is Req —	
Com OK	veneer 1/8		
OK			
Com OK	veneer 1/16		
OK			
OK	low apart 3		
Com OK	Edge V		
OK			
Com OK	Edge V		

Wants 8 min cool
to be sure

100%

1123E

~~Hoffman to get Rubber Co to make one rubber with 6" 1/32 raise ~~ ~~of~~ with hole in~~

Hoffman to make four rounds using 6" 1/32 Extra Rubber on big rubber but with a hole cut out just size of label —

1124E 1st Round

Press 41 — 7 load

C ok — Veneer 1/8 + ck'd Veneer

OK ok

OK ok

OK ok

OK ok

OK ok

OK ok

OK ok

OK ok — Loose spot — 3

OK ok

OK ok

OK ok

100%

2 defects

1124 2nd Round

Press 42 Loaded 11

Com ok — 2 edge + Veneer slight

OK ok

OK ok

OK ok

OK ok

OK ok

C ok — veneer 1/32 slight

OK ok

OK ok

OK ok

C ok — veneer 1/32 very slight

OK ok

100%

3 defects

1124-E

2 Rounds of 152213 -

With Edge taken off more so soft fin part is off.

More to take off whole of soft fin part of Edge of powder blank to see if it would stop Veneer peeling off at Edge

42 Load 10

~~12 Regular Edges not rounded to check~~

Discard-Veneer

OK ok

OK ok

C ok — veneer 1/8

C ok — Edge 1/32 too 2" off

C ok — Edge ✓

OK ok

OK ok

C ok — Edge 1/32 short + 1 ✓

C ok — veneer

C ok — veneer 1/8 + Edges

OK ok

C ok — veneer

8 defects

91%

1125 E 1st Round 5 Mins at 850 42-load 13	2nd 6 Min at 850 42 load 13	3rd Round 8 Min at 850 lbs. 42-load 13	4th Round 10 Min at 850 42-load 13
OK OK Low spot 2	Com OK Edge V	OK OK	OK OK
Com OK Edge V + Veneer	OK OK	Edge Crushed OK DISCARD	OK OK
Veneer OK DISCARD	Com OK veneer	OK OK low spot 3	OK OK
Veneer OK DISCARD	OK OK	OK OK	OK OK
OK OK	OK OK	Veneer OK DISCARD	OK OK
OK OK	C OK veneer	OK OK	C OK veneer
OK OK low spot 3	Veneer OK DISCARD	OK OK	OK OK
OK OK	OK OK	OK OK	C OK veneer
Com OK veneer	OK OK	OK OK	OK OK
Com OK veneer	OK OK	OK OK	C OK Edge
Com OK veneer	Veneer + Edge OK DISCARD	OK OK	C OK veneer
OK OK	OK OK	OK OK	OK OK
		OK OK	
83%	83%	83%	100%

1125 E

1522 B.

Print jug a schedule one round 850 lbs pressure for 10 minutes

One round 850 lbs for 8 minutes

one round 850 lbs for 6 "

one round 850 lbs 5 "

This shows a very great range & margin — 10 to 12 min w OK —

Note

From this Experiment all nicked blanks Not more than 3/32 in towards music Can be Printed

1126 E

Select 1 Round of blanks Chipped at Edges which do not go in towards music More than ~~3/16~~ 3/32 Select by Image

42-Load 3	old	
Venier DISCARD ok	V ok	Edges Bad DISCARD ok
ok ok	V "	Venier pitted in feed line ok — Edges Same
ok ok	V "	
ok ok	V ok	
ok ok	V ok	
Copy ok Venier	V ok	
ok ok	V ok	
ok ok	old Edge ok	66 %
ok ok	Edge ok Same	
Venier DISCARD ok	Edge Same	
ok ok	V ok	

1127 =

Edge Discard also Veneer Gap
OK

Com OK Edge V + veneer

Com OK veneer $\frac{1}{8}$

Com OK veneer $\frac{1}{16}$

OK OK

OK OK Low 3

Com OK veneer

OK OK

Com OK veneer $\frac{1}{16}$

OK OK

Com OK veneer + V Edge

Com OK veneer $\frac{1}{16}$ + Edge Crushed

1127 E

One round 1522 B.

$\frac{1}{4}$ inch ~~[illegible]~~ of Edge has Extra Varnish after 1st Coat dried – Varnish Comes over Edge just a little,

The Extra Varnish

Makes it Coarse

1128

1st Round

Pieces 41 Load 3

Veneer ok — DISCARD — Low all around 1

Veneer ok — DISCARD — Low all around 1

Veneer ok — DISCARD — Low all around 1

Edge ok — Discard — Low all around 1

Veneer ok — Discard — Low all around 1

Veneer Veneer — Low all around " — DIS 1

Edge ok — Low all round — DISCARD 1

Edges ok — Low spot — 3

Com ok — Low all round 1

OK ok — Low all around 1

Com ok — veneer Low all round 1

Veneer ok — Discard — Low Spot of 3

33%

2nd Round —

Veneer Veneer + Low at — Discard 1

Pull out veneer — DISCARD

Edge bad Veneer bad — Discard low all 1

Veneer ok — Low at 1 all round — DISCARD

Com ok — veneer

Com ok — Veneer

Veneer Edge — Discard — Low all round 1

Veneer + Edge ok — Low at 1 — DISCARD

Veneer ok — Low all round — Discard 1

Edge + Veneer ok — Discard

Edge + Veneer ok — Discard

Edge bad ok — Low at 1 all round — Discard

16%

1128 E

Two rounds 1522 B.

The blanks varnished starting at the inside or Label + varnish outward —

Prevent Rep

Thin Varnish at Edge Bad —

Also apparently cause of low spots at 1/3 lbs caused by Thin Varnish —

NOTE

1129E

2 Rounds Varnished with
Varnish 1130E

See next page for
Record

1130E 42 – 14 load	2nd Process Press 40 load 15	
OK ok	OK ok	
Blank Cracked Veneer DISCARD ok –	Com ok veneer	
OK ok	Com ok veneer	
OK ok	Com ok veneer	
OK ok	Blank Cracked Veneer DISCARD ok	
OK ok		
OK ok low 1	OK ok	
Com ok Edge V	Com ok veneer	Dont help Veneer
Veneer DISCARD ok	OK ok	
Com ok Edge Veneer DISCAR ok	Edge DISCARD ok	
	Com ok veneer + Edge	
66%	66%	

1130-E

Hoffman make a quart of 1019 Varnish with Viscosity of 3/4 of a minute instead of 1 minute –

Note Surfaces not so good as Reg 1 min Var show tendency RO on start + it does not Cure the veneer problem at the Edge –

1131 E
42-14 load
1st Round

Com ok Veneer 1/8

Pull onto feed line - ok
Veneer + Edge DISCARD
ok

OK ok

Com ok Veneer

Com ok - Veneer

Veneer - Discard
ok
Veneer DISCARD
ok
Veneer DISCARD
ok
Veneer DISCARD
ok
Edge - DISCARD
ok
Veneer DISCARD
ok

33%

2nd Round

42-load 14 -

Veneer way on Music DISCARD
ok
Veneer pull on Music Edge DISCARD
ok

OK ok

Veneer, way onto Music also bad Edge DISCARD
ok

Com ok - Veneer 1/8

OK ok

Edge horrible + Veneer DISCARD
ok

Veneer ok

OK Com Veneer

Veneer DISCARD
ok
Edge bad DISCARD
ok
Veneer DISCARD
ok

41%

1131 E

Hoffman

Make quart
1019 with Viscosity
1/2 minute

Very Bad too much
Alcohol -

1132 E

2 Rounds Varnished with

1131 E Var

1133E

Print 8 Rounds of blanks having Edges Rounded by Moore

Print in different presses & Loads -

Print Rec

1st Round	2nd	3rd	4	5	Lot 28 6 Moore Edge	Lot 28 7 Moore Edge	8 Moore Edge
Press 30 Load 11	40 Press Load 10	Press 29 Load 16	Press 36 Load 9	Press 31 Load 5	41 Press Load 4	37 Press 6 Load	Press 42 Load 13
OK OK small Label PO	OK OK parallel ✓ Crack long	OK OK	OK OK	Veneer PO OK DISCARD			
OK OK	OK OK	OK OK	Com OK Veneer PO V V	OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	Com OK Edge V V	Com OK Veneer PO ⅛ V	OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	Com OK Edge V	OK OK	OK OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK OK	OK OK Chk Veneer Cant heck	OK OK	OK OK long parallel Veneer Crack	Com Com up Veneer PO Slight	OK OK
OK OK	OK OK	OK OK 2 Chk Veneer	OK OK Parallel Veneer Cracks	OK OK	Com OK Veneer PO Small	OK OK	OK OK
Com OK Edge not broken out yet ✓	OK OK ⅛ of Edge Crumbled long	OK OK	OK OK parallel Veneer Cracks - Probably Edge	OK OK	OK OK	Veneer PO OK Small DIS	OK OK Veneer PO Very slight not Edge Edge
Com OK Cracked ✓ Type probably Edge no PO		OK OK		OK OK	Com OK Edge ⅛ Veneer Chk	OK OK	OK OK
Com OK Veneer not Chk PO.	OK OK	OK OK	Veneer PO several OK DISCARD	Veneer PO OK PO DIS	OK OK long V chk long V CK	OK OK	OK OK
OK OK slight ✓ Crack	OK OK	OK OK	OK OK	Veneer PO " " DIS	Com OK Veneer PO Small	OK OK	OK OK
OK OK chk Veneer long	OK OK	Veneer PO Edge broken BAD	OK OK	OK OK	OK OK V chk	Veneer PO OK DISCD	OK OK
Veneer PO OK probably Edge	OK OK	OK OK	Veneer PO much OK DISCARD	OK OK	OK OK	Com OK Veneer PO	OK OK
	OK OK		Spec - knocker OK DISCARD		OK OK V crack slight	OK OK	Edge ck not PO OK Veneer PO
1 Veneer PO	no Veneer PO 1 Edge slight						
91%	100%	91%	75%	75%	100%	83%	91%

1134 Round 1st	2nd Round	3rd Round	4th Round
42-load 12	41-load 2	42-load 9	41-load 5
OK OK	Com OK Edge	OK OK	Com OK Edge V.
Com OK Veneer PO	Veneer OK Edge	OK OK	Com OK Edge V vv
OK OK	Veneer OK V DIS	Com OK Veneer PO	OK OK
Com OK Edge small	OK OK low 3	Com OK Edge.	OK OK Veneer long ck
Edge Bad OK DIS	OK OK	OK OK	OK OK
Com OK veneer cks	OK OK low spot 2	Com OK Veneer PO	Edge OK DISCARD
Com OK Edge	OK OK	Com OK veneer ck	OK OK
Com OK veneer cks	OK OK	OK OK	OK OK
OK OK	Com OK Edge V	OK OK	OK OK
OK OK	OK OK	OK OK low 3	OK OK veneer ck long
OK OK	OK OK	OK OK	OK OK low spot 3
Edge OK DISCD	OK OK	OK OK	OK OK
			OK OK
83%	83%	100%	91%

1134E

4 Rounds on blanks 1522X with new load of chalk with 8% Lime

Print Reg

Pulp	50.0 %
Chalk	37.5
	12.5
	100.0

This Chalk OK —
Reexamined Nov 27/16

Mostly fine V fine + VV fine surfaces
+ all Satisfactory good starts no RO —

Monday Factory % 1522B

83.6%

out of 1739 Oks –
The Edgers apart 253.
by the handling –
all done on Bengle
Edgers —

10 Blanks 1522B

Varnished on Oth Machine

OK OK bag apart, fair amt.

OK Can hear – loose apart bad

OK OK

OK OK

OK OK

OK OK

C OK veneer + Edge ✓

C OK veneer or Edge

OK OK

OK OK

91%

Another round by Fred Ott. felts
only on Each end - $\frac{1}{4}$ thick -
12 = Wooden rounded Edge blanks

OK OK no serial Nos etc
OK OK "
OK OK "
OK OK
OK OK
OK OK
OK OK
OK OK
OK OK
OK OK
OK OK

100%

Hard Experiment

Records
Ediing 152213 on Mandrel
Multiple -
Inspect for serial numbers
& engraving

OK OK
OK OK
OK OK
OK OK
OK OK
OK OK
OK OK
OK OK
OK OK
OK OK

This is the way
E

100%

2nd Round

1 — Veneer — will reprint
2 " "
3 Veneer will Edge
4 Veneers — will Edge
5 Veneer will reprint
6 " " Think OK by Edging
7 " Try Edging — it will reprint
8 Veneer will reprint,
9 " "
10 " + Edge will reprint + Edge
11 will Edge OK —

5—23—16

Discarded by Eye Inspector
CRACKED EDGE

1 Discard
2 — Not cracked out — ~~the~~ Edge ~~on~~ it.
3 — Probably do for reprint
4 = " " "
5 Veneer only will reprint
6 " "
7 " "
8 " "
9 Discard Edge
10 Veneer will reprint.
11 Veneer + Edge will reprint + Edge
12 Veneer — will reprint.

2nd Round Edging Mach Discards

1 = OK - only 1/32 nick
2 7/16 chips in 1/2 mach to 1/8 feed line Edger done it
3 7/16 " in to 3/16 of feed line Edger done it
4 5/16 - chpd in 1/16 Edger
5 Edged to 3/16 - chipped in 1/16 - Edger
6 5/16 - chipped in 1/32
7 3/8 - chpd to 1/16 of feed line - Edger
8 7/16 - big chip within 1/8 feed line "
9 5/16 - 1/16 chip - Edger
10 5/16 1/16 chipd in -
11 3/16 - chipped in 1/16 of feed line Edger
12 5/16 " in 1/16 - Edger

Thick 1/2 accepted by the Edging Machine -

Good Records passed by Eye Inspection which broke out in Single Edging Machine

1 = Edged to 1/4" & broke out of oks coming down to 1/4"
2 - 5/16 - then chipped out 1/16 2 planes
3 1/4 - broke out 1/16 - looks like a good veneer originally
4 5/16 - broke out 3/16 - not originally in but by machine.
5 - 3/8 - broke out to within 1/16 feed line looks like machine -
6 5/16 chipped in 1/16
7 5/16 1/16 chip 1/2 long done in Machine
8 5/16 chipped to 1/16 feed line done in Edger
9 3/8 " 1/4 - veneer pushed off Edger
10 5/16 " 1/32 done in Edger
11 5/16 " 1/32 "
12 5/16 " 1/32 - veneer stripped done by Edger

1135 E Press 42 Load 16

OK OK

Com Com | op cracked Edge in situ

OK OK

T Top OK Veneer PO

T Top Com OK veneer PO, Edge poly

T Com OK veneer PO "

OK OK

B Com OK Edge v v

B Com OK Edge Good

| OK Veneer PO DISCARD

T Com OK Veneer PO + Edges V

OK OK

75%

Press 41 Load 8

Blank stuck on Mould

Very hard get off -

OK OK

T Top OK Edge Bad DISCARD

OK OK

T Com OK veneer PO

T Com OK veneer PO

T Com OK veneer PO

B | OK Edgeband Discard

B | OK Edge DISCARD

B Com OK veneer PO

T OK veneer PO Discard

B Com OK veneer PO

T OK Edge Very bad Discard

58%

NG

1135 E

Huffman - make

Quart Van no free phenol

no Sandrac - 7 1/2 6/4

1% Para

Vacuity 1 minute

Blanks stick very

hard to Mould

Varnish Cant be used

1136E

2 Rounds, with Varnish
No 1134 E 1 Coat,

Print Regular

1137

1st Lot put Thru Mill
Required 2 ½ hours for 1 gal

But Another lot put
thru same mill twice
Required only 2 hours
for twice —

14" Mill —

Twice through is very very
much finer than our regular
Var & satisfactory
I note fibre in —

1137E

Hoffman takes Reg
1019 Var 1 min Viscosity
to Newark to grind in
a Mill — try it
2 Rounds for surface

Lot A once thru Mill

Lot B twice thru Mill —

Lee Cook

NOTE

Low spots at 1 2 & 3
position due to Varnishing
starting at Edge to Varnish
+ proceeding inwardly
Low spots at 3
Reverse & start at
hole low spot all
at 1 + all around
DEE 1121 + 1128 E.

Hoffman

Mouldo Recd	Top	Bot			
18th.	8	10			
			Set Ring		
23	41	26	247	23	5003
24	71	75	285	24	4935

Daily Production 1523 B Blanks

18th 2306

Monday 22 - 1522 Morelos Road

	Monday	Tuesday	Wed	Thurs	Friday	Sat
On hand	161 sets	176 sets				
Bottoms Tops	22 Bot 7 Top	22 Bottom 7 Tops				

Luke

	Top plates	Bottom
May 19	17	25
Luke 20	25	9
22	27	23
23	24	36

Blankets Made	Leg 5	Leg 6
Saturday 20th	2156	888
Monday	2184	1507

[ITEM(S) FOUND IN BOOK]

Re examination 1134E

fine -

1 V fine -
2 V fine -

3 VV fine surface
4 Extra VV ~ Dimmed

5 - V fine
6 VV fine -

{ 7 fine -
{ 8 V fine -

{ 9 VV fine -
{ 10 VV fine Extra -

[ITEM(S) FOUND IN BOOK]

1534-1141 E B.

233-239	.006
242-247	.005
238-243	.005
230-241	.011
233-238	.005
218-220	.002
232-246	.014
228-243	.015
228-250	.022 ✓
218-232	.016
246-256	.010
233-238	.005
233-249	.016
228-253	.025 ✓
230-239	.009
211-221	.010
231-238	.007
231-240	.009
231-247	.016
240-247	.007
238-248	.010
228-245	.017
226-251	.025 ✓
226-246	.020

Pressed with 1/8 x 1/4" disc in center 200 lbs. pressure.